

Date: Thursday, 08/11/2007 10:30:46 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	ACCESS PANEL ASSEMBLY
Job Number :	34240		
Estimate Number :	12948		
P.O. Number :	N/A	Part Number :	D3259041
This Issue :	08/11/2007	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3249 REV A1
First Issue :	23/08/2007	Project Number :	N/A
Previous Run :	33655	Drawing Revision :	A1
	Type :	Material :	N/A
	SMALL /MED FAB	Due Date :	03/09/2007
Written By :			Qty: 4 Um: Each
Checked & Approved By :			
Comment :	Est Rev:A New Issue 07-07-19 JLM Verified By:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Assembly Kit

2.0	D32591	panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 panel
 Batch: 34736

3.0	D32593	Doubler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Doubler
 Batch: B 34251

4.0	D32595	Spacer
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Spacer
 Batch: B 34737

5.0	D32597	Door
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
 Door
 Batch: 34254 318 B 34738

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Job Number: 34240

Part Number: D3259041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	D31615	Hinge 9.9"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Hinge 9.9"

Batch: B33671 1K B34735 3X 6

7.0	D32601	Spring
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Spring

Batch: 34255 6

8.0	127H5	HALF GROMMET
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

HALF GROMMET

Batch: M105518 6

9.0	250018C3Y	RIGHT RECEPTACLE
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

RIGHT RECEPTACLE

Batch: M10034 6

10.0	2501W20020C3Y	STUD
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

STUD

Batch: 100398 6

11.0	MS20426AD44	Rivet
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch: 1021 6

12.0	MS20470AD34	Rivet,Universal Head
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Comment: Qty.: 36.0000 Each(s)/Unit Total : 144.0000 Each(s)

Rivet,Universal Head

Batch: 15541 6

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Job Number: 34240

Part Number: D3259041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

MS20470AD35

Rivet



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet

Batch: 9682

CU 7/11/08 (9)

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3259-041 as per Dwg D3259 .

Note:Keep .040" Gap all around door.

ml 07/11/09 x4

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6 07/11/09 (x4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: ST 182

AS 07/11/09 (4)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 07/11/12

Job Completion

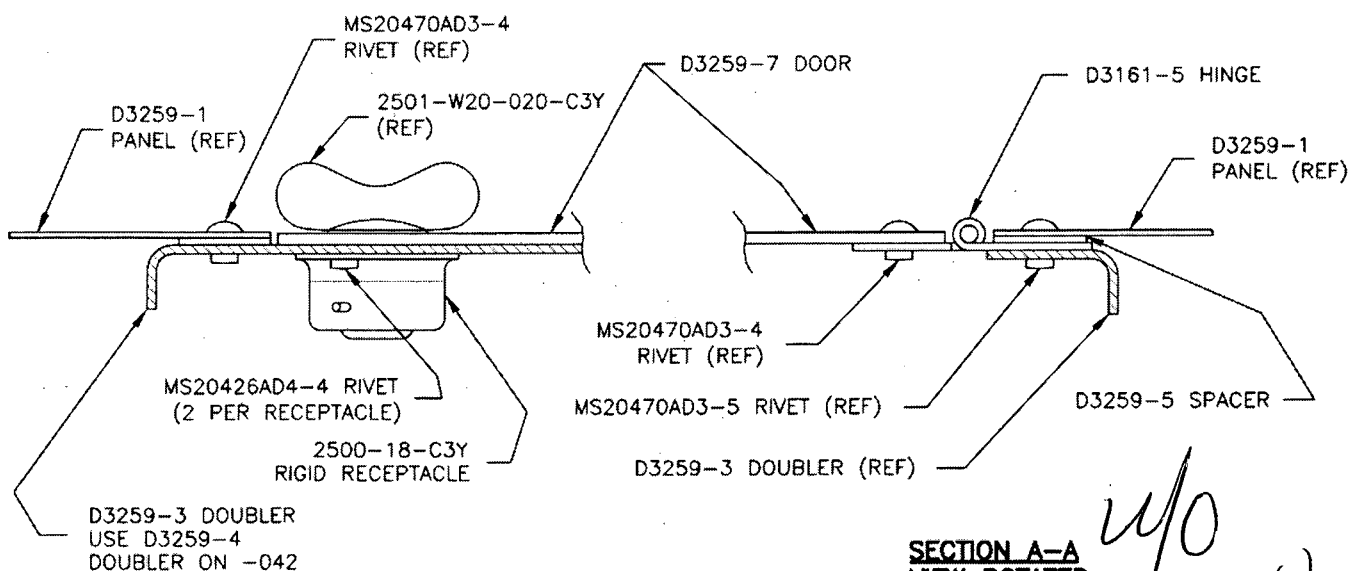
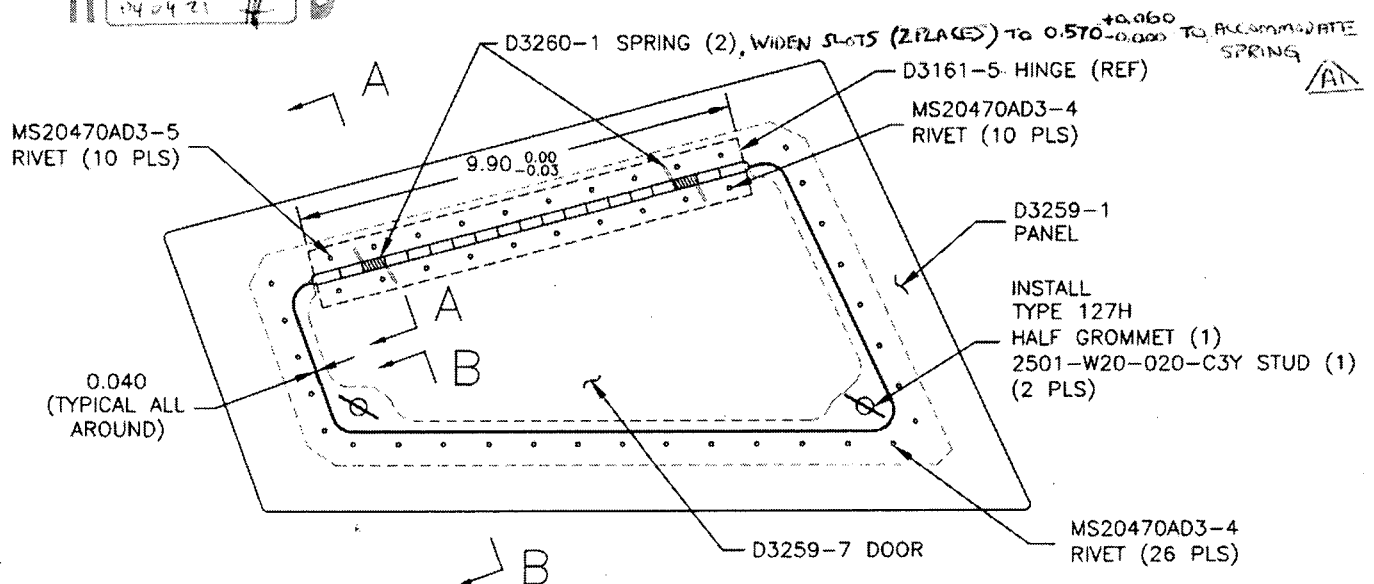


U 07-11-12



DESIGN	RF	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	#	APPROVED	DRAWING NO. D3259 REV. A SHEET 1 OF 6
DATE	04.02.25	TITLE	ACCESS PANEL ASSEMBLY SCALE 1:4
A	04.02.25	NEW ISSUE	
A1	04.08.11	WIDEN SLOTS TO ALLOW OPERATION OF SPRING	

RELEASED
140421



SECTION A-A
VIEW ROTATED

4/0
34240

D3259-041 ACCESS PANEL ASSEMBLY (SHOWN)
D3259-042 ACCESS PANEL ASSEMBLY (OPPOSITE)

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

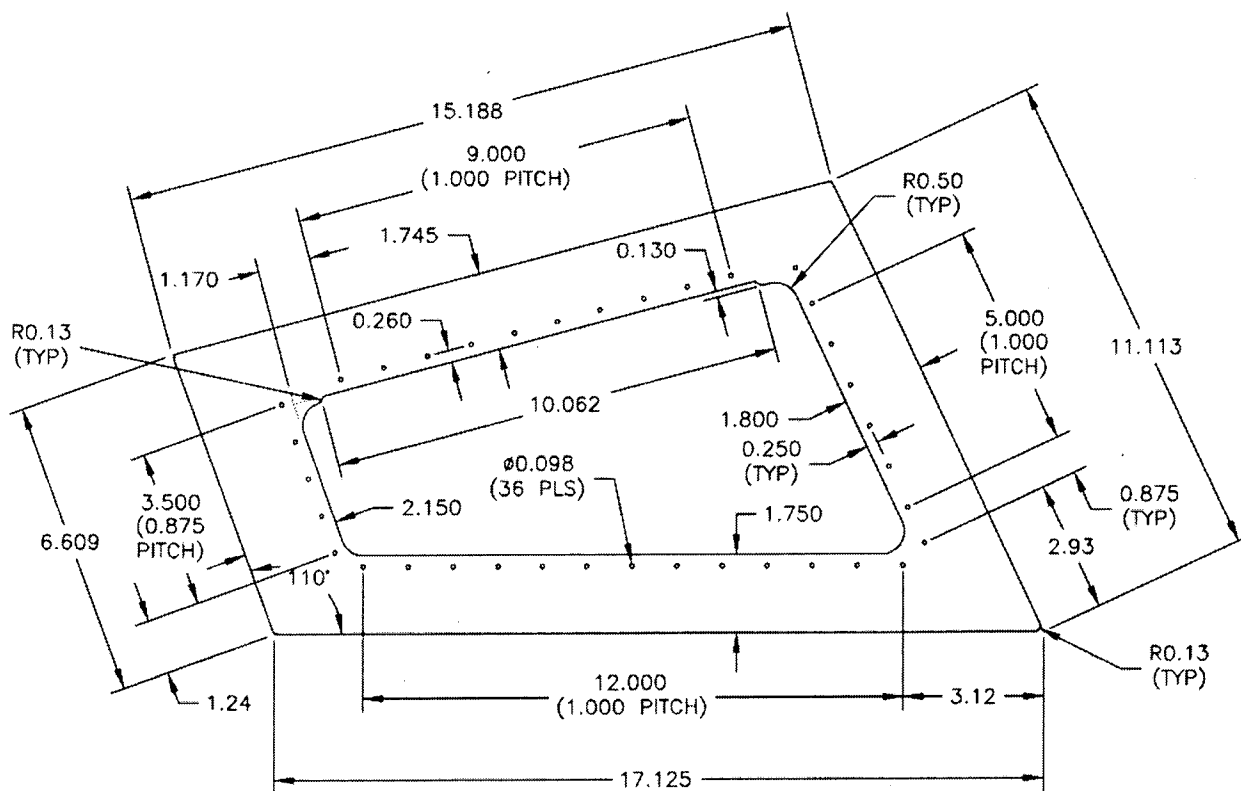
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3259	REV. A SHEET 2 OF 6
DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
[Stamp]



D3259-1 PANEL

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

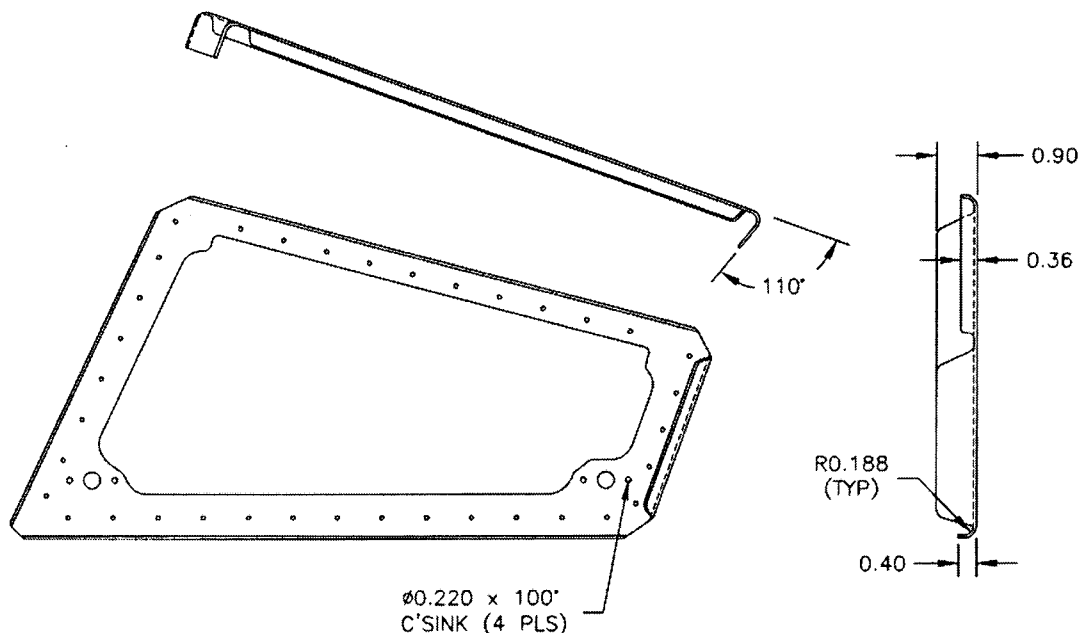
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.04.14



D3259-3 DOUBLER BEND DETAIL (SHOWN)

BEND D3259-4 DOUBLER (OPPOSITE)

D3259-3/-4 NOTES:

- 1) MANUFACTURE PER "D2359-A4.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

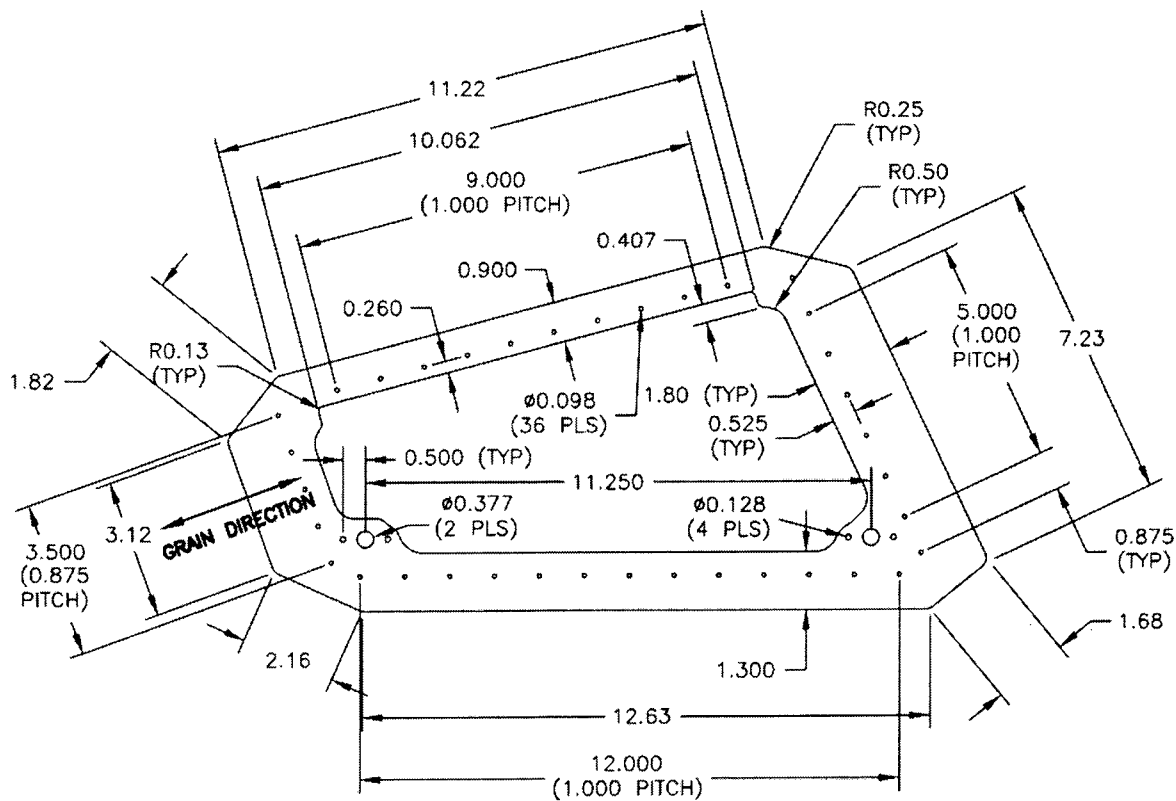
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04 04 14



D3259-3/-4 DOUBLER FLAT PATTERN
($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

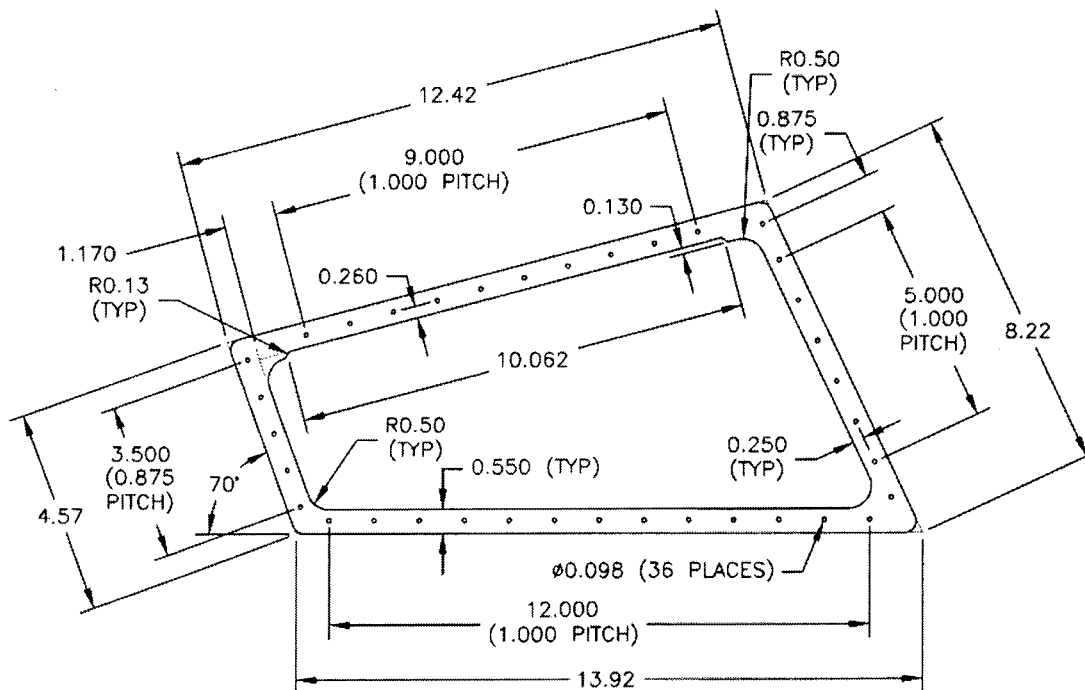
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DATE 04.02.25		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:4

RELEASED
04.02.25



D3259-5 SPACER

($\phi 0.098$ HOLES TO COINCIDE WITH HOLES IN D3259-1)

NOTES:

- 1) MANUFACTURE PER "D3259-A5.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

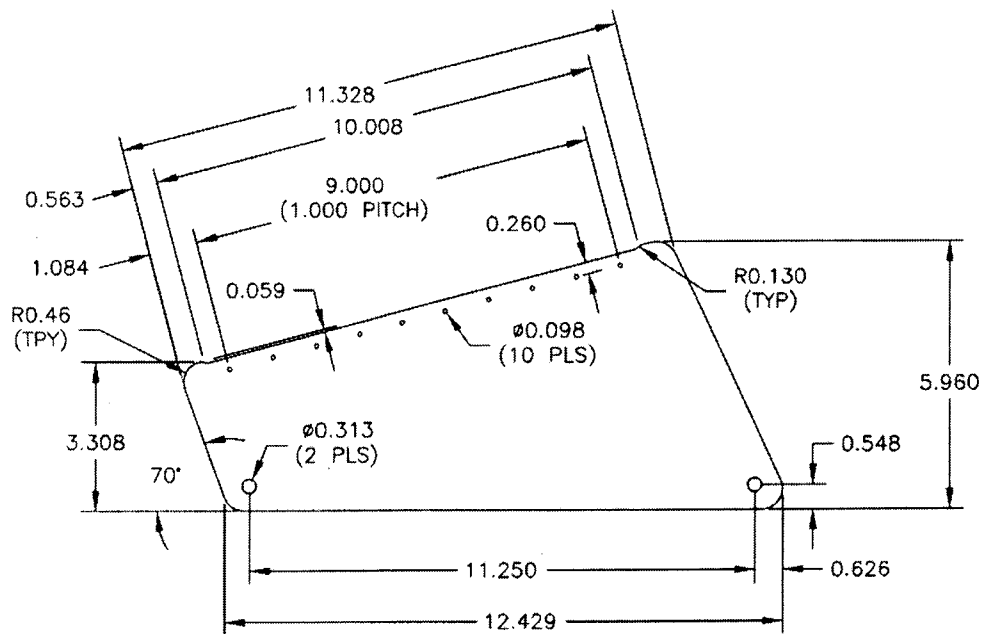
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DATE 04.02.25	TITLE ACCESS PANEL ASSEMBLY		SCALE 1:4

RELEASED
04-04-14



D3259-7 DOOR

NOTES:

- 1) MANUFACTURE PER "D3259-A6.DWG"
- 2) MATERIAL: 2024-T3 (QQ-A-250/4) 0.063 THICK (M2024T3S.063)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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